

# Work Order ID 61912

Thursday, September 09, 2010 1:15:51 PM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 9/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-09 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 005

8.10.10/08

for BG 10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Stop

Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)  
\*\*\*ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT8150\*\*\*7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Clecko DT9642 and drill fwd saddle holes on second side, ensure proper positioning.

9-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

10-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

BB 10/09/14

SAD  
10-09-29 (1)

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.297".

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: ☐

13-Grind welds flush as per Dwg D2750

SAD  
10-09-24  
①

M114877 BE 10/09/16

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/09/24

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/09/24

②

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Run Start  
StopSequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



HandFinish

Memo

0.00

0.00

SAD 10-09-24

①

Hand Finishing

150



QC

QC3- Inspect Part Finish

Memo

0.00

0.00

DP 10-9-24

Quality Control

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Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: M115114  
exp. date: 11-1-308- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)A/R ☐☐☐ Aluminum Rod batch: M114877

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

SAD  
10-09-24 ①SAD  
10-09-27

W/O:		WORK ORDER CHANGES					
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Run Start



Stop

Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

BE 10/09/28

12-Debur holes

BE 10/09/28

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S.10/09/28

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S.10/09/28

②

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Stop

Sequence ID/  
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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

0.00 =&gt; JH

1010105

1 0



HandFinish

Memo

0.00

Hand Finishing

✓ 1- Install inserts as per Dwg D2750

=&gt; JH 1010105

230

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

✓ BATCH: M115114EXP DATE: 11/01

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

✓ A/R 55-o-ring lube batch: M1141895-Coat all exposed fasteners with "LPS Procyon" batch: M114596

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Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/10/06

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

8/10/10/07 ①

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

8/10/10/08

Quality Control

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

B61912

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Stop

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DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

NEV h

280

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/10/08

10/10/12

MF  
10-10-12

W/O:		WORK ORDER CHANGES					
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Thursday, September 09, 2010 1:15:55 PM

\_\_\_\_\_

**Required Date:** 9/17/2010

**Required Qty: 1.00**

**Comments:** IPP Rev:I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:J 06-03-23 As per Rev D JLM  
 IPP Rev:K 06-07.13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec  
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010  
 DD verified by:EC IPP Rev:P 10.06.22  
 revise seq110 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 		Manufactured	No			230	Each	147.0000	8	8			
O-Ring, 205 Skidtube													
				<u>Location</u>									
				FP				147					
					55546			19					
					58191			12					
					59358			116					
D2744 		Manufactured	No			110	Each	18.0000	1	1			
Cap													
				<u>Location</u>									
				LG				18					
					59198			18					
D2600-3-BENT 		Manufactured	No			110	Each	16.0000	1	1			
Extrusion Bent													
				<u>Location</u>									
				LG				16					
					59410			1					
					61633			5					
					61634			10					

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# Picklist Print

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Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

203.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

203

50281

10

57953

2

59111

191

B BB 10-9-27

D2739

Manufactured No

160

Each

5.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

5

61637

5

① DP 10-9-24

D3490-3

Manufactured No

160

Each

43.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

43

60294

6

61218

37

4 BE 10-9-27

D3490-1

Manufactured No

160

Each

81.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

81

59424

3

61217

78

4 BE 10-9-27

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Shop Packet Print

Page 2

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Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

220

Each

5,329.000

38

38



Insert



x38 MU 10/10/05

Location

Loc Qty

Loc Code

PK011

5329

110768

5329

x38

D3492-041

Manufactured

No

230

Each

49.0000

8

8



Plug Assembly



41 10/10/05

Location

Loc Qty

Loc Code

FP013

49

59114

1

61311

48

x8

D3793-3

Manufactured

No

230

Each

13.0000

1

1



Wearshoe



41 10/10/05

Location

Loc Qty

Loc Code

FP18

12

61258

12

FP19

1

57947

1

x1

AN8C35A

Purchased

No

230

Each

40.0000

1

1



BOLT



MU 10/10/05

Location

Loc Qty

Loc Code

FP

1

110847

1

ST346

39

114442

14

115188

25

x1

Thursday, September 09, 2010 1:15:55 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:15:55 PM

Work Order ID: 61912

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-1

Manufactured No

230

Each

14.0000

1

1



Wearshoe



10/10/05

Location

Loc Qty

Loc Code

FP18

14

59151

1

59630

1

61244

12

D3488-041

Manufactured No

230

Each

10.0000

1

1



Blade Fitting Assembly, LH



10/10/05

Location

Loc Qty

Loc Code

FP

7

53915

7

FP007

3

56052

3

D3794-3

Manufactured No

230

Each

37.0000

1

1



Gasket



10/10/05

Location

Loc Qty

Loc Code

FP10

27

60826

1

61712

26

FP18

10

56066

9

59153

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:15:55 PM

Work Order ID: 61912

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010


Start Qty: 1.00

Required Qty: 1.00

AN6C44A Purchased No 230 Each 125.0000 4 4  
  
 BOLT


<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
103964	2	
ST344	123	
111649	2	
114653	1	
114941	75	
<u>115030</u>	45	

HL 10/10/05

MS21083C8 Purchased No 230 Each 69.0000 1 1  
  
 NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST303	69	
113845	5	
114934	14	
<u>115594</u>	50	

HL 10/10/05

D3536-25 Manufactured No 230 Each 36.0000 1 1  
  
 Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP12	36	
59625	10	
<u>61707</u>	26	

HL 10/10/05

HL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:15:55 PM

Work Order ID: 61912

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

467.0000

8

8



Washer



ML 10/10/05

Location

Loc Qty

Loc Code

ST072

193

60755

193

X8

ST076

274

52693

206

54388

68

D3791-1

Manufactured No

230

Each

7.0000

1

1



Wearplate



ML 10/10/05

Location

Loc Qty

Loc Code

FP17

7

58573

7

B61702

V1

AN960C10L

NAS1149C0332

Purchased

No

230

Each

155.0000

38

38



washer

M115816



X38 ML 10/10/05

Location

Loc Qty

Loc Code

ST245

155

107534

29

109545

54

111548

72

D2745

Manufactured No

230

Each

165.0000

8

8



Bushing



ML 10/10/05

Location

Loc Qty

Loc Code

ST023

165

52311

5

59112

60

61203

100

X8

Thursday, September 09, 2010 1:15:56 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, September 09, 2010 1:15:56 PM

Page 7

Work Order ID: 61912

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,530.000

34

34



Bolt



41 10/10/05

## Location

## Loc Qty

## Loc Code

ST350

1520

114330

11

115015

209

115108

300

115316

300

115371

100

115422

100

115594

500

ST351

10

113121

10

X34

D3537-1

Manufactured

No

230

Each

21.0000

3

3



Wearpad



41 10/10/05

## Location

## Loc Qty

## Loc Code

FP

1

55465

1

FP17

6

57713

3

60491

3

FP18

14

61201

14

B61640

X3

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER



41 10/10/05

\* NAS1149C0832R / M114915 \*

Thursday, September 09, 2010 1:15:56 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:15:56 PM

Work Order ID: 61912

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

230

Each

75.0000

8

8



Plug Assembly

\*



10/10/06

Location

Loc Qty

Loc Code

FP

2

B61842\*

x8

54682

2

FP013

73

59117

1

59190

4

61207

8

61503

60

AN3C6A

Purchased

No

230

Each

301.0000

4

4



BOLT



10/10/05

Location

Loc Qty

Loc Code

ST351

301

111982

301

x4

NAS1611-013

Purchased

No

230

Each

232.0000

8

8



O-RING



10/10/05

Location

Loc Qty

Loc Code

FP

232

114451

32

115460

100

115589

100

x8

D3535-25

Manufactured

No

230

Each

9.0000

1

1



Wearshoe



10/10/05

Location

Loc Qty

Loc Code

FP18

9

59623

9

y1

B61706

Thursday, September 09, 2010 1:15:56 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:15:56 PM

Work Order ID: 61912

Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010



Start Qty: 1.00

Required Qty: 1.00

D3794-1	Manufactured	No	230	Each	32.0000	1	1
							<u>21 10/10/04</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP010	32	
57942	6	
61704	26	<u>X1</u>

MS21043-6	Purchased	No	230	Each	674.0000	4	4
							<u>21 10/10/04</u>
NUT							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST301	674	
112314	674	<u>X1</u>

D3493-1	Manufactured	No	260	Each	24.0000	2	2
							<u>21 10/10/04</u>
Washer							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST065	24	
60873	24	<u>2</u>

MS21083C8	Purchased	No	260	Each	69.0000	1	2
							<u>21 10/10/04</u>
NUT							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST303	69	
113845	5	
114934	14	
115594	50	<u>2</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 09, 2010 1:15:56 PM

Work Order ID: 61912



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

AN8C21A	Purchased	No	260	Each	33.0000	2	2	
BOLT								

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST345	33	
113558	1	
114653	32	

8 AN960C816L <i>NA51149C08322</i>	Purchased	No	260	Each	0.0000	1	2	<i>11/16/03</i>
WASHER								<i>M114915 10/10/10</i>

D3672-1	Manufactured	No	230	Each	901.0000	4	4	
Phenolic Washer								<i>M 10/10/10</i>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST077	901	
42329	150	
<u>52505</u>	751	

8 D2741	Manufactured	No	260	Each	45.0000	1	1	<i>75</i>
Blade, 350 Skidtube								<i>10/10/10</i>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST466	45	
57949	7	
60210	38	

8 D3532-1	Manufactured	No	260	Each	9.0000	2	2	<i>75</i>
Spacer								<i>B61673 10/10/10</i>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST068	9	
60510	9	

Thursday, September 09, 2010 1:15:56 PM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 11

Thursday, September 09, 2010 1:15:56 PM

Work Order ID: 61912



Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 9/9/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

D3672-13

Purchased

No

260

Each

818.0000

2

2



10/10/10

Phenolic Washer

Location

Loc Qty

Loc Code

ST077

818

54363

818

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

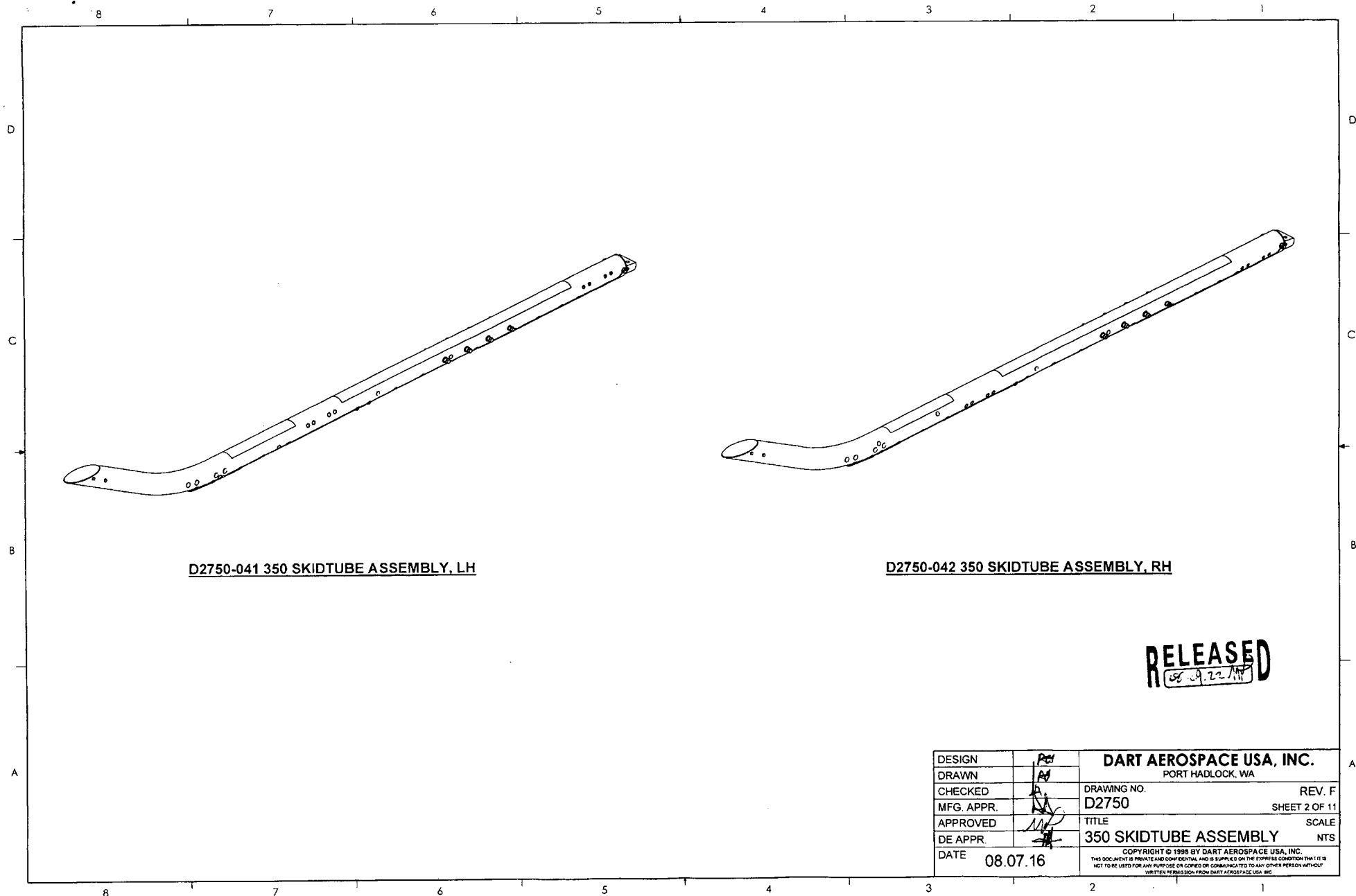
## GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL  $\triangle$
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL  $\triangle$

CL 10/9/24  
W/O: 61912

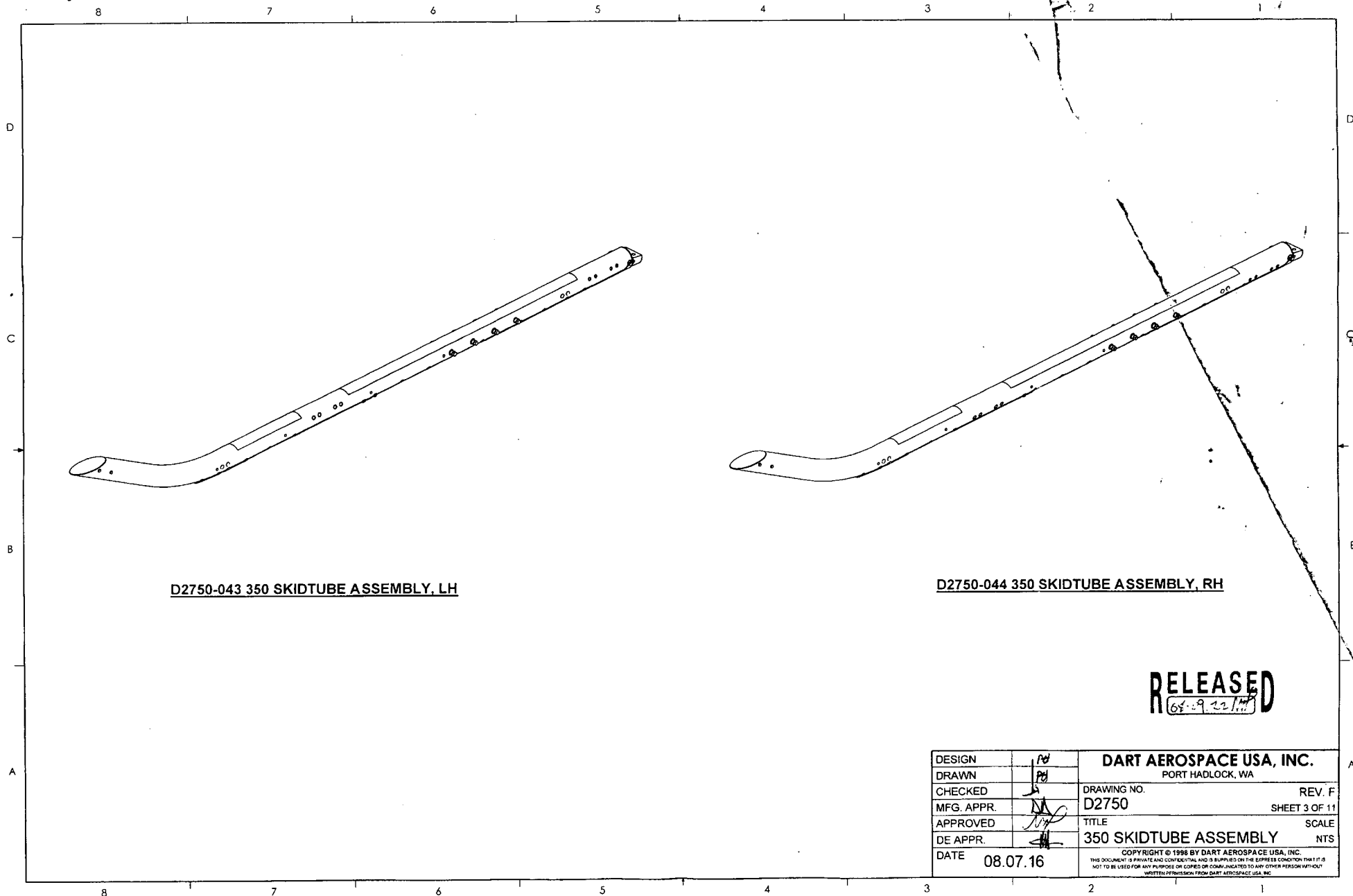
RELEASED  
68-07-22

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	RAH	PORT HADLOCK, WA	
CHECKED	AK	DRAWING NO.	REV. F
MFG. APPR.	AK	D2750	SHEET 1 OF 11
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**RELEASED**  
 08-09-22/MP

DESIGN	PC1	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AD	PORT HADLOCK, WA	
CHECKED	AD	DRAWING NO.	REV. F
MFG. APPR.	AD	<b>D2750</b>	SHEET 2 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



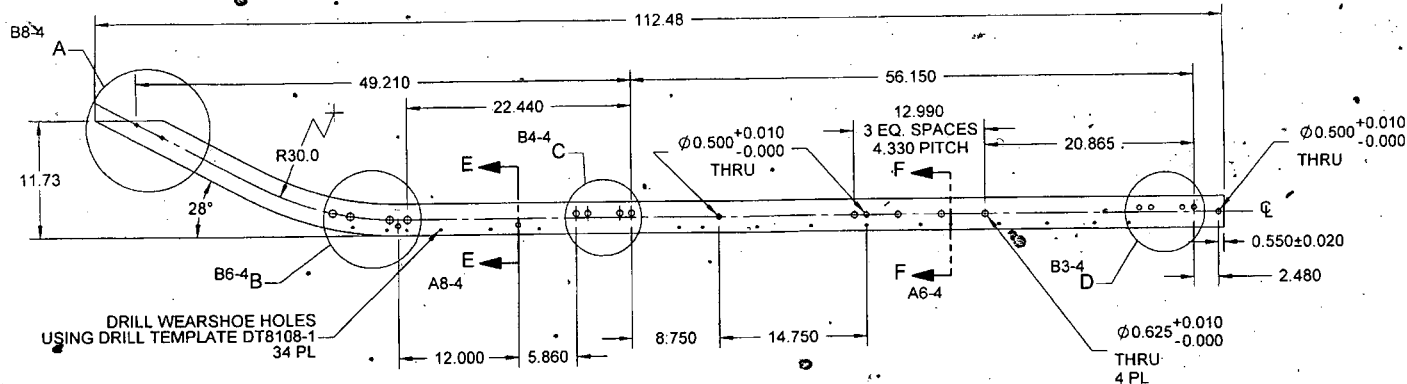
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

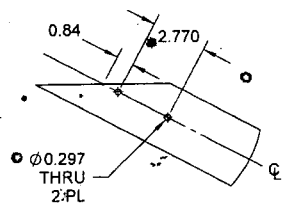
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64-09-12/111

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CHECKED	<i>PD</i>	DRAWING NO.	REV. F
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APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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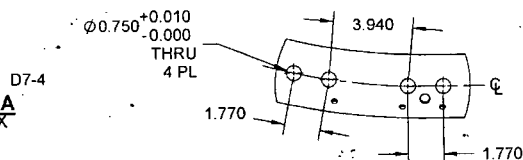




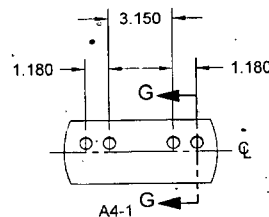
**D2750-1 LH SKIDTUBE**



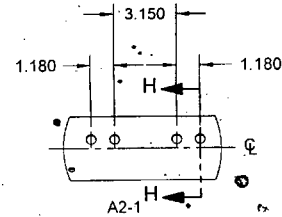
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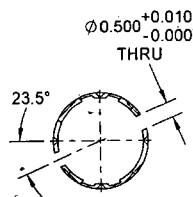
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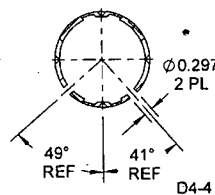
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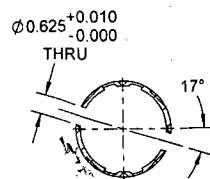
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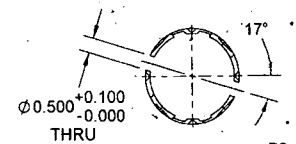
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



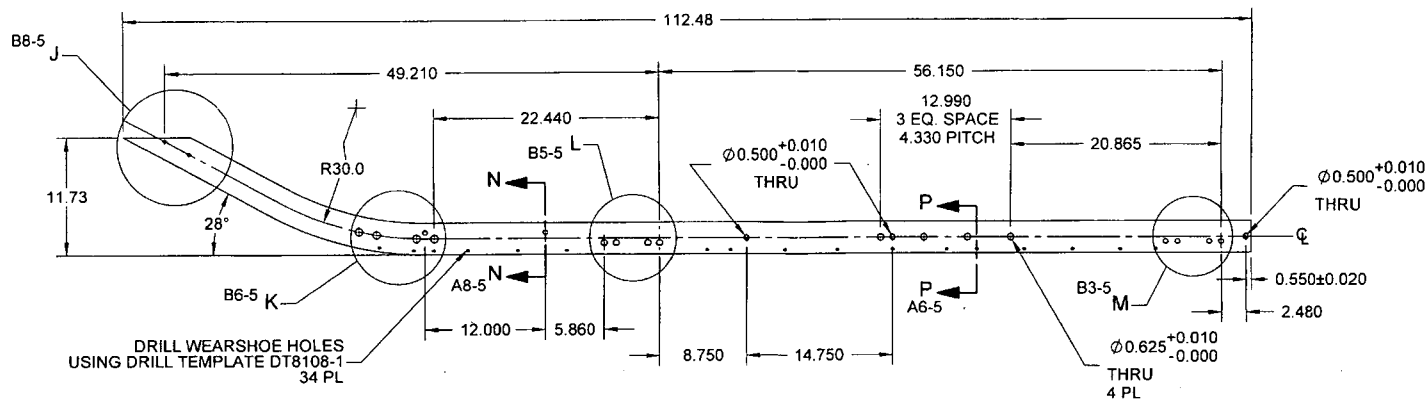
**SECTION G-G**  
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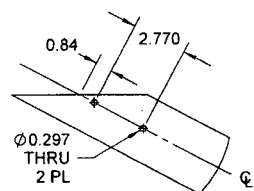
**SECTION H-H**  
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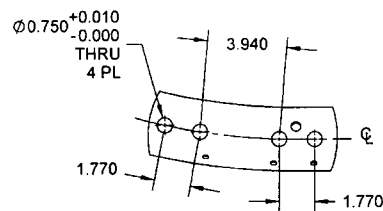
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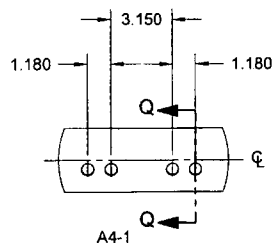
**D2750-2 RH SKIDTUBE**



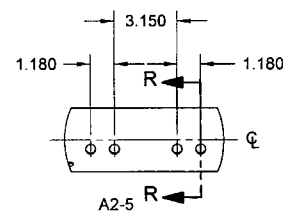
**DETAIL J**  
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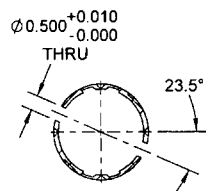
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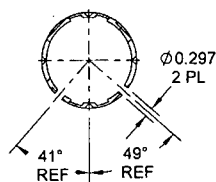
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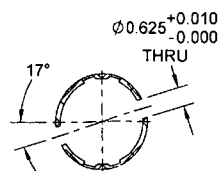
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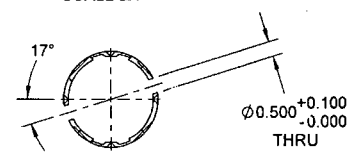
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

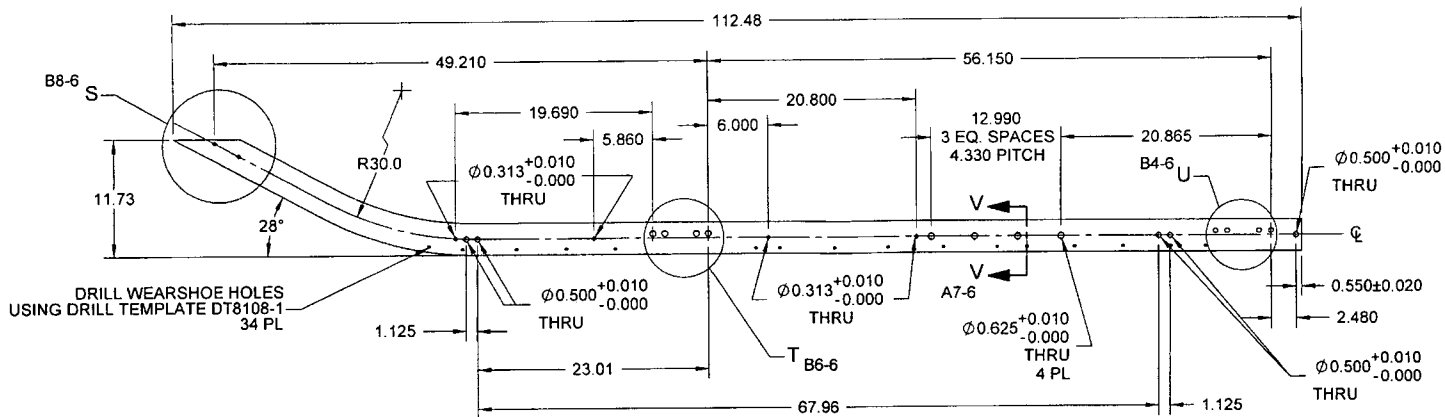


**SECTION R-R**  
SCALE 3X, 4 PL

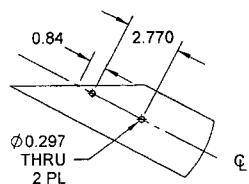
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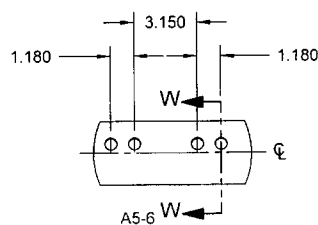




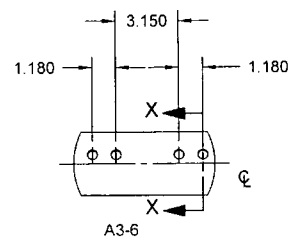
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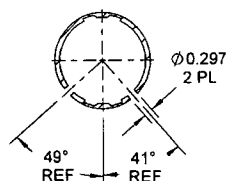
**DETAIL S**  
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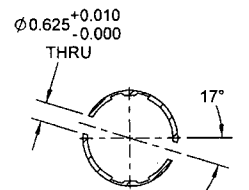
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C5-6  
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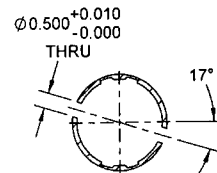
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



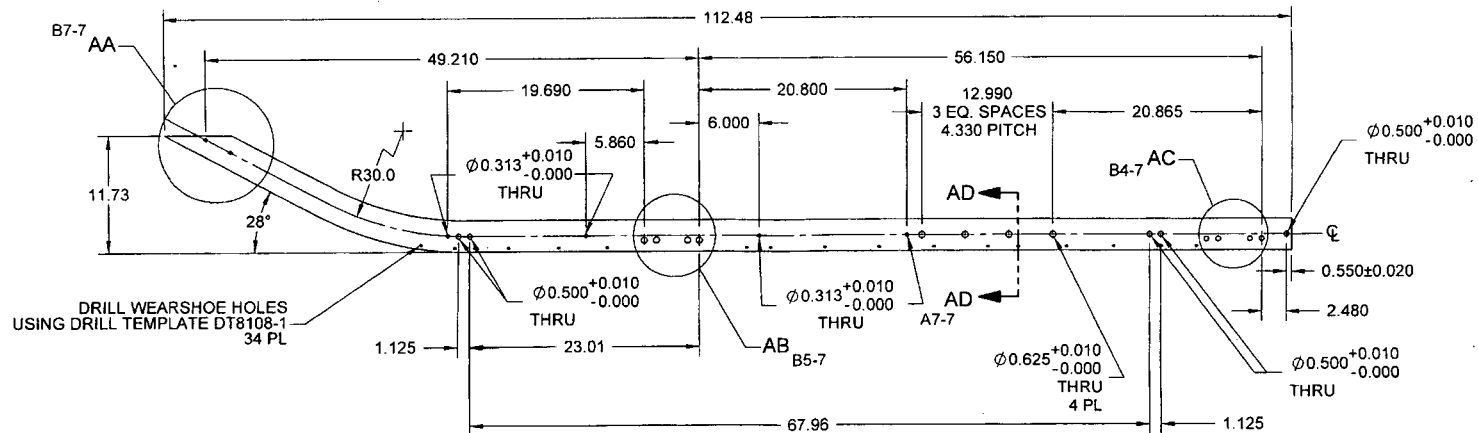
**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



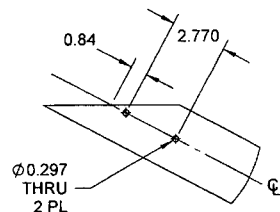
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B4-6  
SCALE 3X, 4 PL

**RELEASED**  
08.22.16

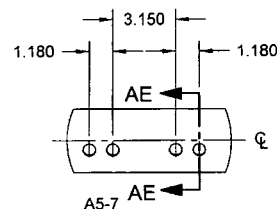
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MFG. APPR.		<b>D2750</b>	SHEET 6 OF 11
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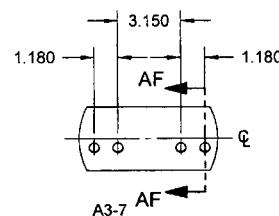
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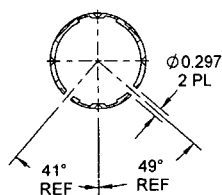
**DETAIL AA**  
SCALE 2X  
D7-7



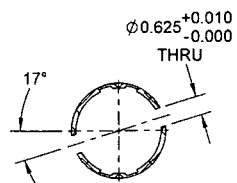
**DETAIL AB**  
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C4-7



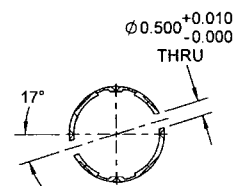
**DETAIL AC**  
SCALE 2X  
D3-7



**SECTION AD-AD**  
SCALE 3X, 17 PL  
D3-7



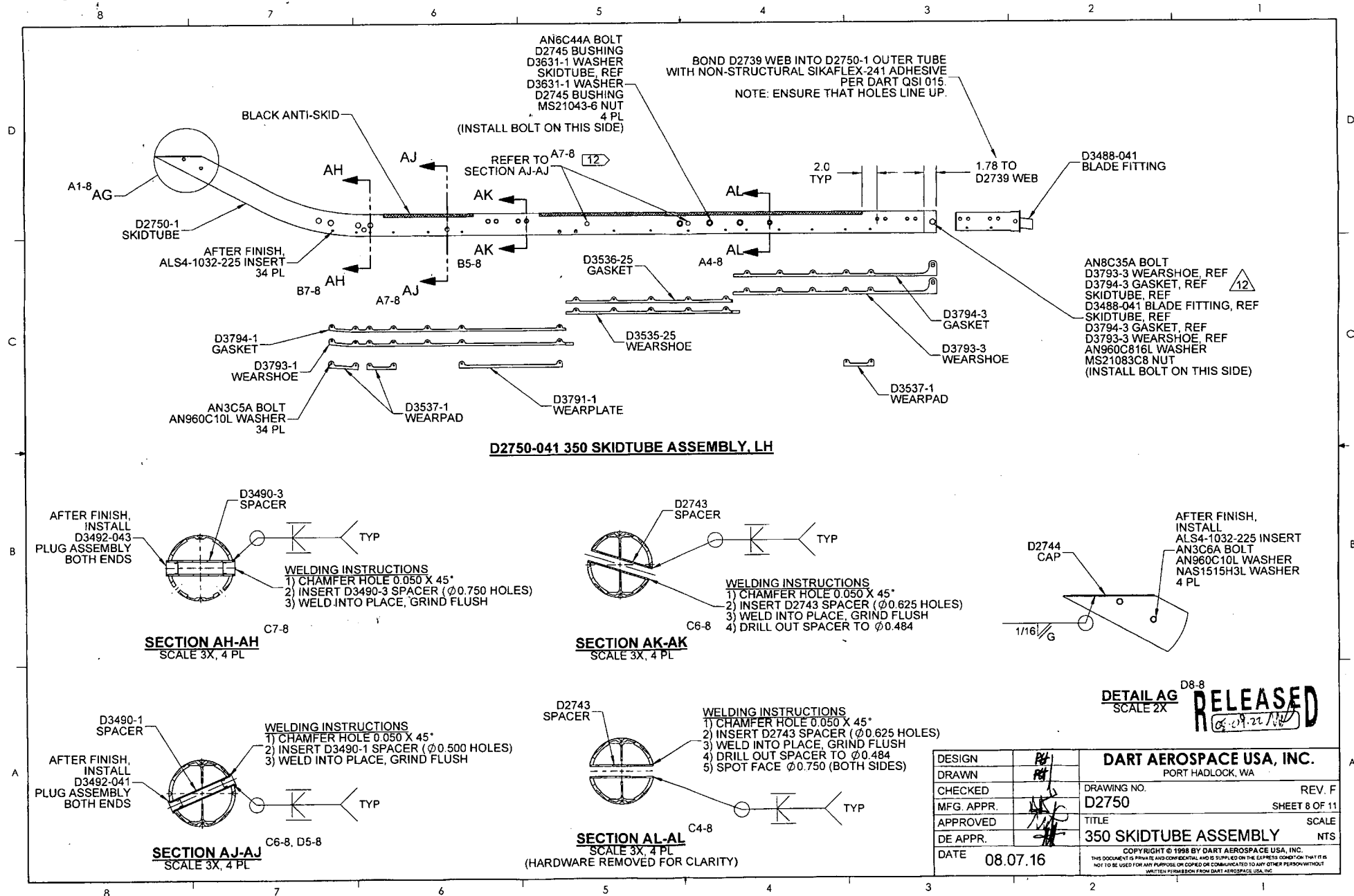
**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7

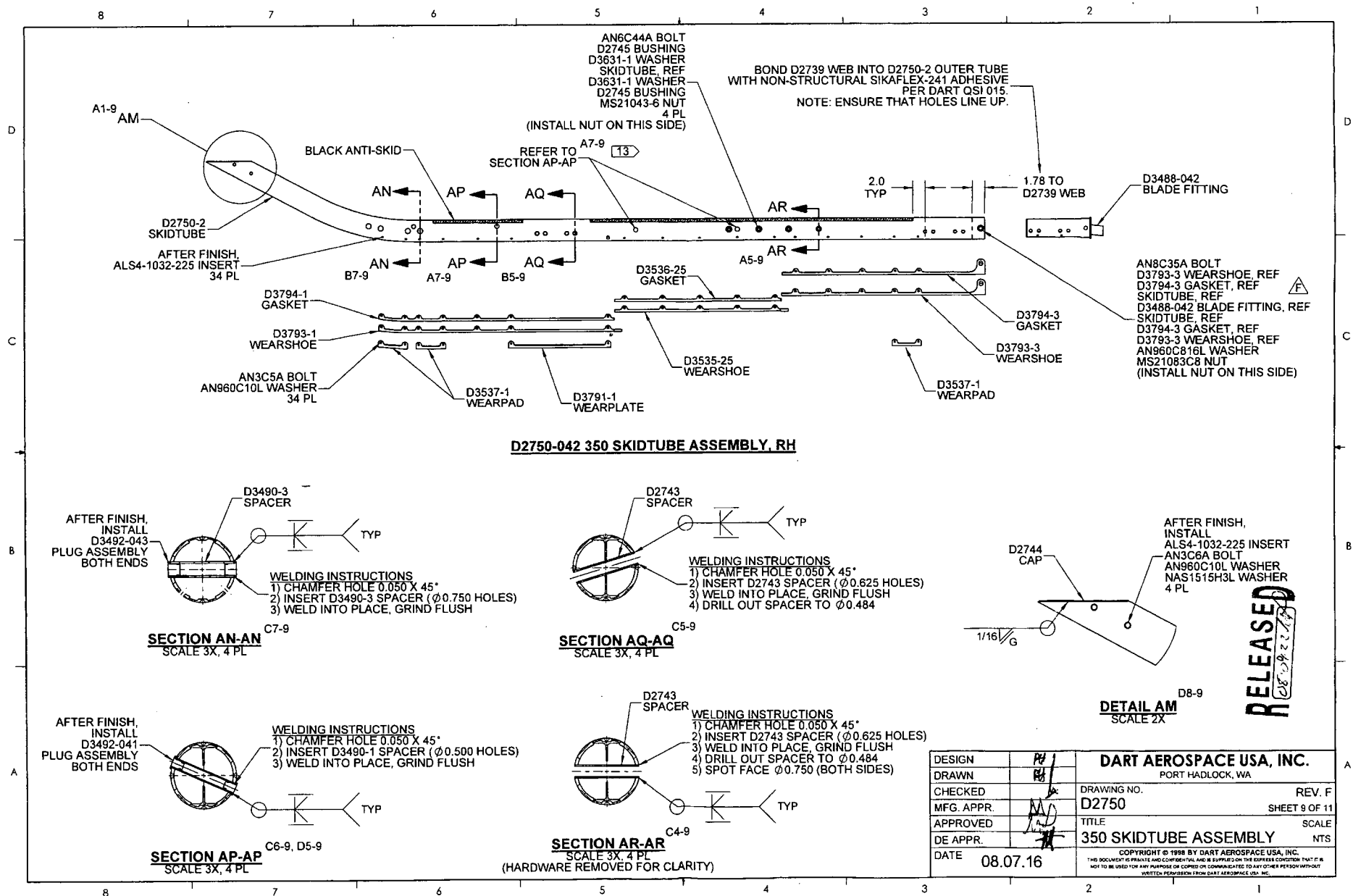


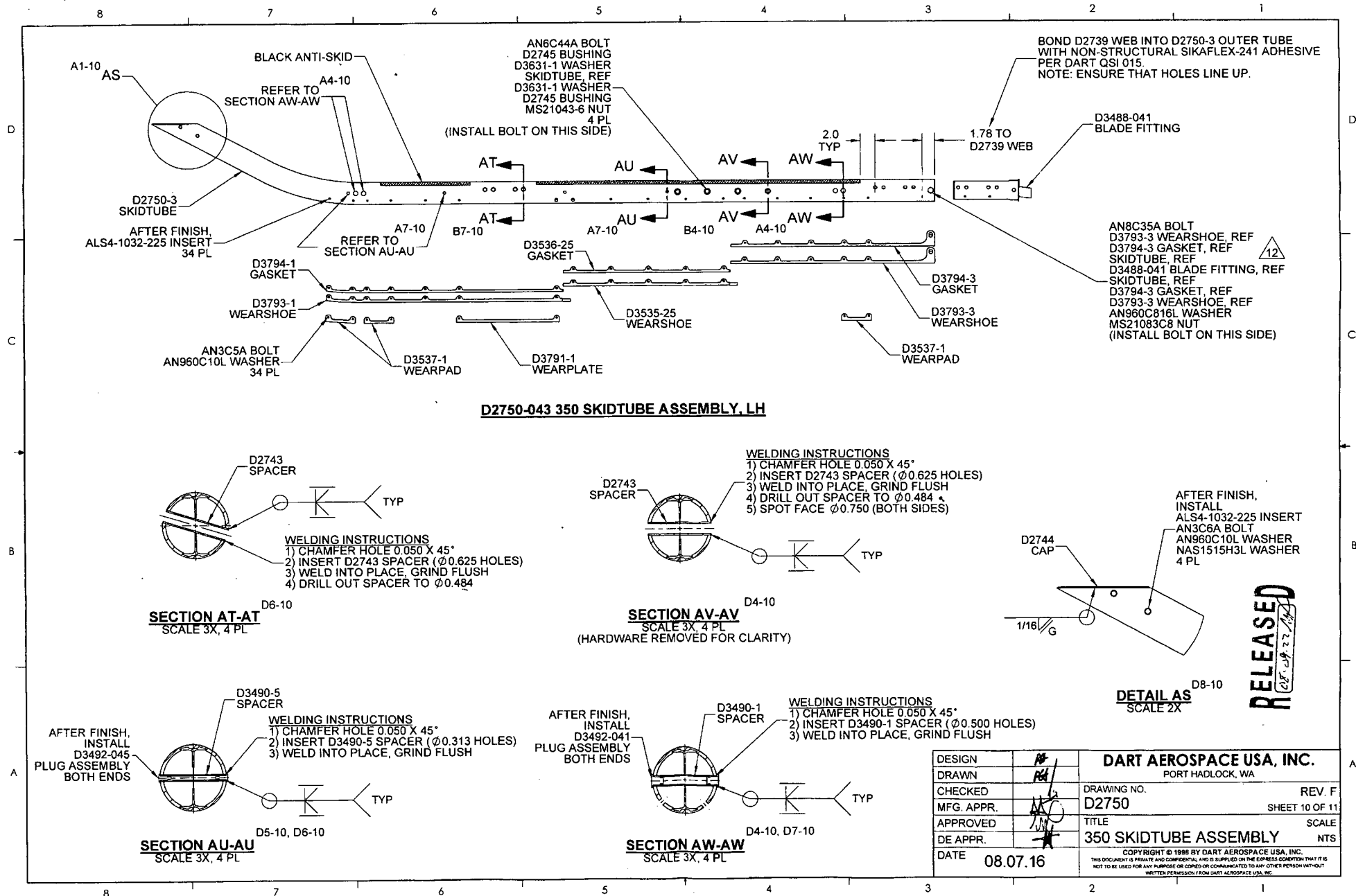
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SCALE 3X, 4 PL  
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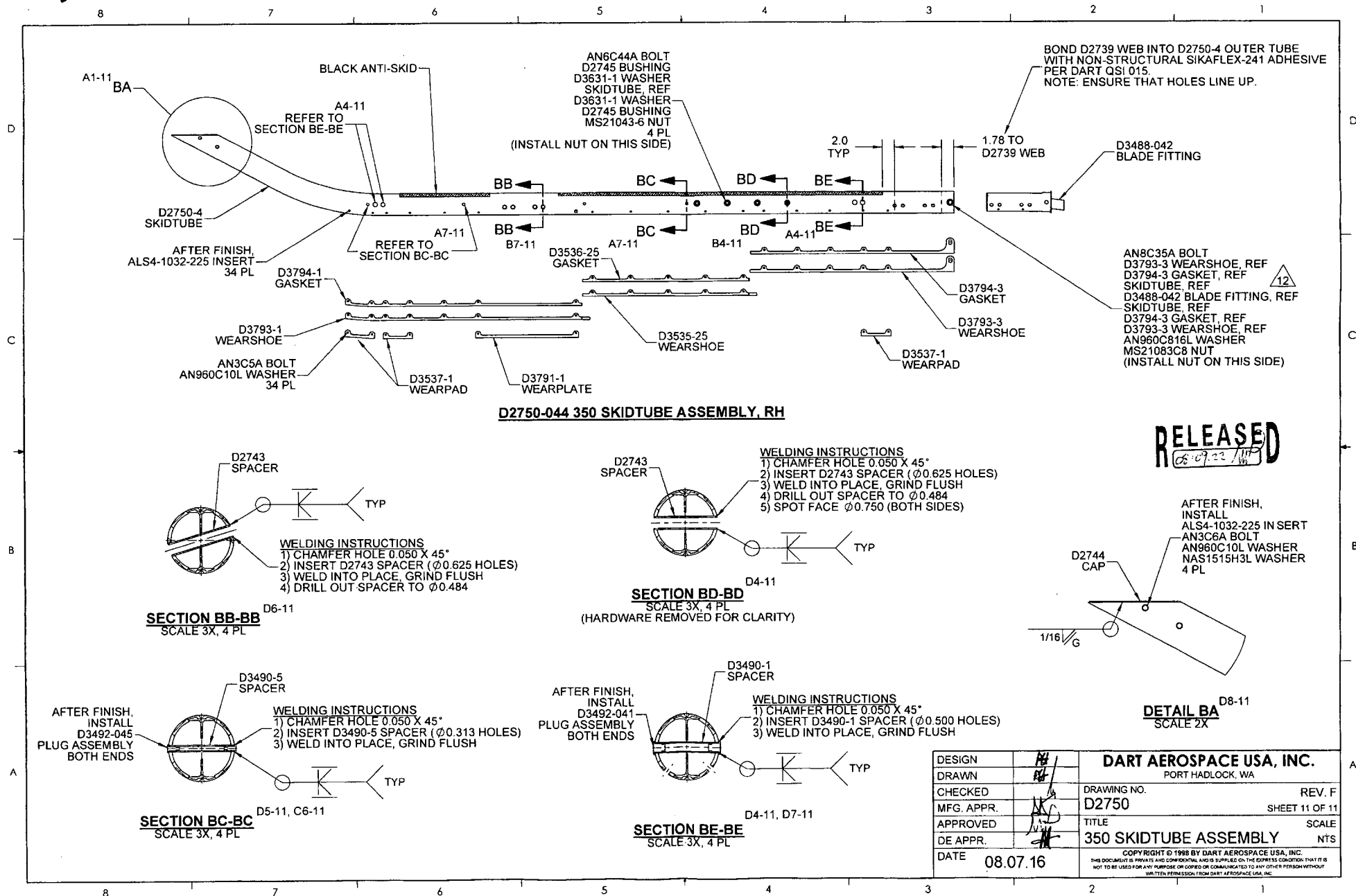
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MFG. APPR.	DA	<b>D2750</b>	SHEET 7 OF 11
APPROVED	AP	TITLE	SCALE
DE APPR.	A	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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NO. 236

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 60988  
Part number: D350-636-012  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier [Signature] Date of Test Coupon 10-08-12

Welder [Signature] Date of Test Coupon 10-08-12

The above named individual is qualified in accordance with AWS D17.1.2001 to weld